

WHAT IS CLAIMED IS:

1. A method of attaching a pair of end caps to a core of a feed roll for mounting to the frame of a master processing apparatus in which a master processing operation is performed, said method comprising:

providing a tubular core with a supply of stock material wound about said core;

providing a pair of end caps each having a tubular core securing portion and a mounting portion connected to said core securing portion, said core securing portions normally being in a relaxed, unexpanded condition to enable insertion of said securing portions into opposing ends of said core, said mounting portions being configured to enable said feed rolls to be mounted on said frame in an operative position;

providing a pair of expansion members each being constructed and arranged to be inserted into the core securing portion of a respective end cap;

inserting the core securing portions into the opposing ends of said core;

inserting an expansion member into each said core securing portion, each said expansion member being configured such that said expansion member radially expands said core securing portion upon insertion therein into a force fit relation with the interior surface of said core, thereby securing each said end cap to said core.

2. A method according to claim 1, wherein said providing a pair of end caps and said providing a pair of expansion members includes providing said end caps and said expansion members such that each end cap and each expansion member is constructed of a molded plastic material and each expansion member is integrally connected to a respective end cap by a frangible connection so that each end cap and the associated expansion member is provided as a single molded plastic component, said method further comprising breaking said frangible connection between each said expansion member and said associated end cap to separate each said expansion member from the associated end cap prior to said inserting an expansion member into each said core securing portion.

3. A method according to claim 2, wherein each expansion member is connected by said frangible connection to a respective end cap in axial alignment with the tubular core securing portion such that said breaking said frangible connection and said inserting an expansion member are accomplished simultaneously by applying an axially directed force to said expansion member.

4. A method according to claim 3, wherein said tubular core is constructed of a paper or a cardboard material and wherein each tubular core securing portion is generally in the form of a cylindrical tube having a split free end, said split free end of each said core securing portion defining a plurality of tabs, each tab including gripping structure on the exterior thereof, said inserting an expansion member into each said core securing portion further comprising radially expanding said core securing portion such that said tabs flex outwardly and said gripping structures grip said paper or cardboard material.

5. A feed roll configured to be mounted to a frame of a master processing apparatus in which a master processing operation is performed, said feed roll comprising:

- a tubular core carrying a supply of a stock material wound thereon;

- a pair of end caps each having a tubular core securing portion and a mounting portion connected to the core securing portion, the mounting portion of each end cap being constructed and arranged to allow the core and stock material to be rotatably mounted to the apparatus frame in an operative position to enable the stock material to be unwound for the master processing operation, said core securing portions being inserted in opposing ends of said core; and

- a pair of expansion members, each expansion member being disposed in said core securing portion of a respective end cap to radially expand the core securing portions of the end caps into a force fit relation with the interior surface of the core to secure the end caps to the core.

6. A feed roll according to claim 5, wherein each said end cap is constructed of a molded plastic material.

7. A feed roll according to claim 6, wherein said tubular core is constructed of a paper or a cardboard material and wherein each tubular core securing portion is generally in the form of a cylindrical tube having a split free end, said split free end of each said core securing portion defining a plurality of tabs, each tab including gripping structure on the exterior thereof, each said expansion member being disposed in each said core securing portion to radially expand said tabs such that said gripping structures grip said paper or cardboard material.